

Work Order ID 51574

August 26, 2009 3:11:21 PM

341P 3408



Page 1

Item ID: D3872-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 8/26/09 Start Qty: 4.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024.000

1-Cut as per Dwg D3872

Dwg Rev: A

Prog Rev: A

2- Deburr if necessary

HB 9-8-22

④

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-8-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51574

August 26, 2009 3:11:21 PM



Page 2

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

27 802/08/08

4

4

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

BR 0208-31

4

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

AL 09/08/31

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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August 26, 2009 3:11:21 PM



Page 3

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Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/08/31 (4)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31 AD

MF 09-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 26, 2009 3:11:20 PM

Page 1

Work Order ID: 51574

Parent Item: D3872-3RevA

Parent Item Name: Doubler

Comments:

Start Date: 8/26/09

Required Date: 8/28/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	139.7029	1.4400			



2024-T3 .050 sheet



18 9-8-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

139.7029

111381

43.7029

112291

96

111381

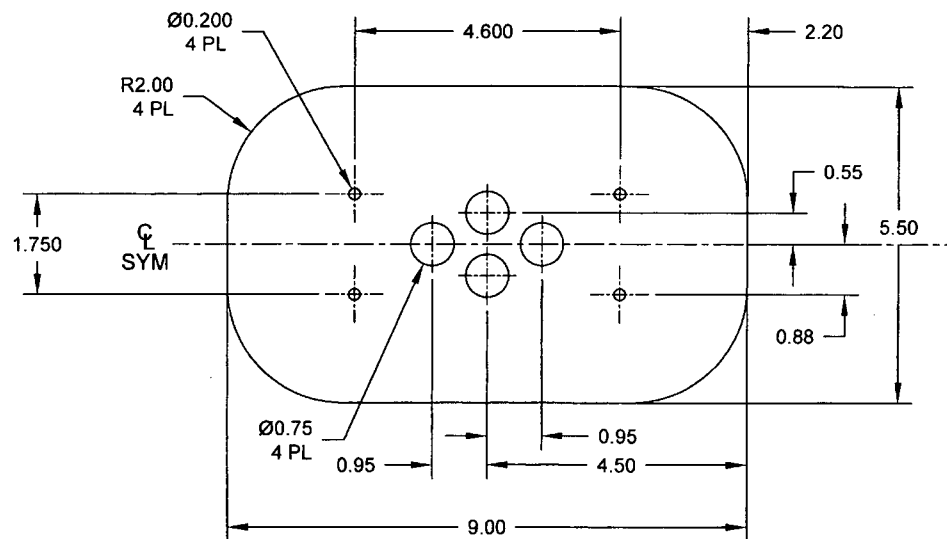
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D3872-3 DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/4 (REF DART SPEC M2024T3S.050)
OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 (REF DART SPEC M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3872-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.5 lbs

DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KB		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	DD	D3872	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOTTOM ANTENNA MOUNTING PLATE	NTS
DATE	09.01.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
07/05/05 NIP

W/O 51574